

Work Order ID 80776

Tuesday, February 28, 2012 3:05:55 PM

80776

Page 1

Item ID: D4018-5

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib

Start Date: 2/28/2012 Start Qty: 9.00

9

Cust Item ID:

Required Date: 3/2/2012 Req'd Qty: 9.00

9

Customer:

Reference:

Approvals: Process Plan: *MWF*

Date: *12-02-28* Tooling:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4018

C

100

0.00

100

Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D4018
2- debur and remove identification markings

Le

12-03-28

X25

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

12-03-29 25x

120

Identify as per dwg & Stock Location:

0.00

120

Packaging

Memo

0.00

Packaging

Backet cell

12-03-29 25x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item Name: Rib

Start Date: 2/28/2012 Start Qty: 9.00

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Required Date: 3/2/2012 Req'd Qty: 9.00

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/3/29

12-03-29

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 80776

Parent Item: D4018-5

Parent Item Name: Rib

Start Date: 2/28/2012

Required Date: 3/2/2012

Start Qty: 9.00

Required Qty: 9.00

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as per dwg revA 10.03.15
verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP
Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049 Square Tubing		Purchased	No			100	f	348.2521	0.5558	5.2654737			

Ac 12.03.28

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT034	348.2520653	
116610	0.8383	
117721	0.3234	
117999	2.43919739	
<u>118460</u>	344.651168	

146263158332

Dart Aerospace Ltd

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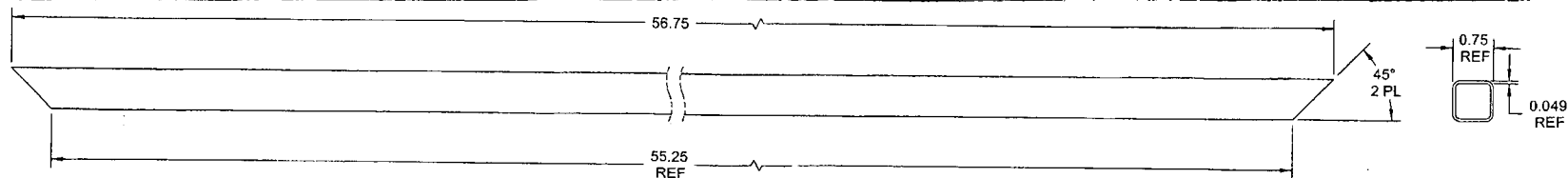
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

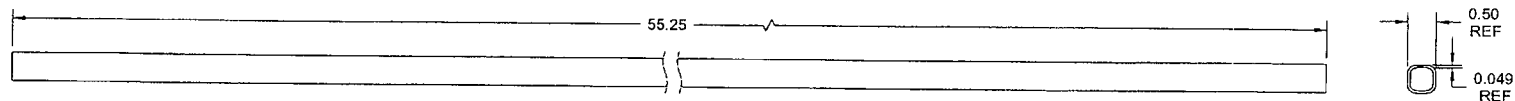
D



D4018-1 RIB

C

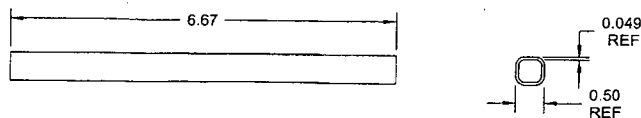
C



D4018-3 RIB

B

B



D4018-5 RIB

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

80776

RELEASED
10.08.05

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	ISC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ISC	DRAWING NO. D4018	REV. C
MFG. APPR.	ISC	SHEET 4 OF 4	
APPROVED	ISC	TITLE	SCALE
DE APPR.	ISC	SHORT BASKET LID ASSY (350) NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

A

A

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